

# Work Order ID 84215

**\*84215\***

Page 1

Item ID: D3140-303

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Doubler

Stop **\*NS2\***

Start Date: 08/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/05/08

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3140	Rev F					(4)			
100		0.00							
<b>*100*</b>	FLOW WATER JET								
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
6061 .063	1-Cut as per Dwg D if necessary								
	Dwg Rev: <u>F</u> Prog Rev: <u>F</u> 2-Deburr								
110		0.00							
<b>*110*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								
120		0.00							
<b>*120*</b>	QC8- Inspect parts - second check								
QC		0.00							
Quality Control	Memo								

1B12-6-87

1B12-6-87

5.266127

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**NOTE:** Date & initial all entries

# Work Order ID 84215

May-08-12 8:37:03 AM

**\*84215\***

Page 3

Item ID: D3140-303

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Doubler

Stop **\*NS2\***

Start Date: 08/05/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 22/05/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

4x 4 JH 12/07/10

170

Identify as per dwg & Stock Location: 271A

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

4x 12/7/10

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

MJ 12/07/10

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**NOTE:** Date & initial all entries

# Picklist Print

May-08-12 8:37:07 AM

Page 1

Work Order ID: 84215

\*84215\*

Parent Item: D3140-303

\*D3140-303\*

Parent Item Name: Doubler

Start Date: 08/05/2012

Required Date: 22/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 02.11.06 New issue KJ/RF  
IPP Rev B 06.04.18 New dwg rev. ecn781 EC  
IPP rev.C 06.04.25 Waterjet EC  
IPP rev.D added scuffing NCR 061 EC  
IPP Rev:E As per ECN #829 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	367.1422	2.7777	11.69558	12.		

\*M6061T6S 063\*

6061-T6 .063 Sheet

\*\*

1312-6-07

Location

Loc Qty

Loc Code

MAT021

367.1422000

113608

0

116308

6.01556842

117285

67.544

119331

44.2

119802

18.94

120218

19.5

120866

66.9426316

121578

144

121805

121805

4

# Dart Aerospace Ltd

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**NOTE:** Date & initial all entries





DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

RELEASED

06.11.13

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 89215 MJS  
12/05/08

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
				1	1	D3140-85	ANGLE
1	1					D3140-87	DOUBLER
				1	1	D3140-89	DOUBLER
		1				D3140-91	DOUBLER
			1			D3140-92	DOUBLER
3	3					D3140-95	DOUBLER
1						D3140-97	DOUBLER
	1					D3140-98	DOUBLER
		1	1			D3140-99	DOUBLER
		2	2			D3140-101	DOUBLER
		1				D3140-103	DOUBLER
			1			D3140-104	DOUBLER
		1				D3140-105	DOUBLER
			1			D3140-106	DOUBLER
1	1					D3140-241	DOUBLER
1		1				D3140-301	DOUBLER
	1		1			D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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**NOTE:** Date & initial all entries



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77  
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006  
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.  
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND  
ALODINE PER DART QSI 005 4.1



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# Dart Aerospace Ltd

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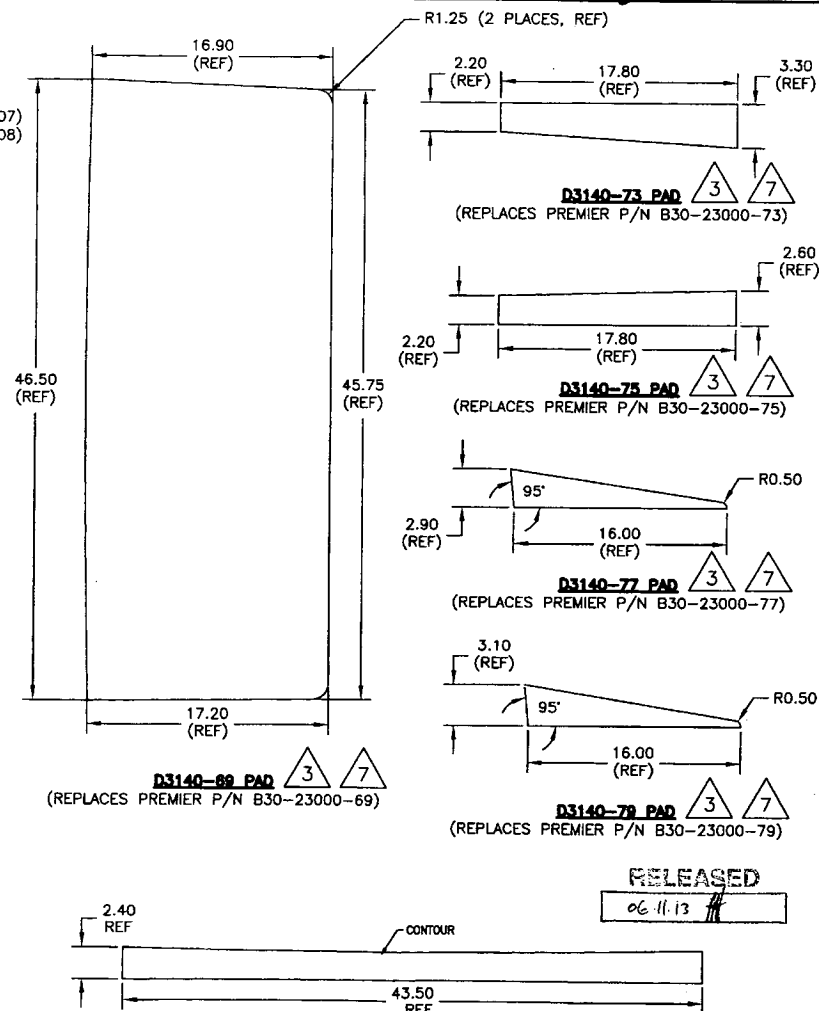
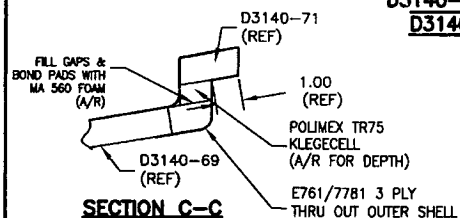
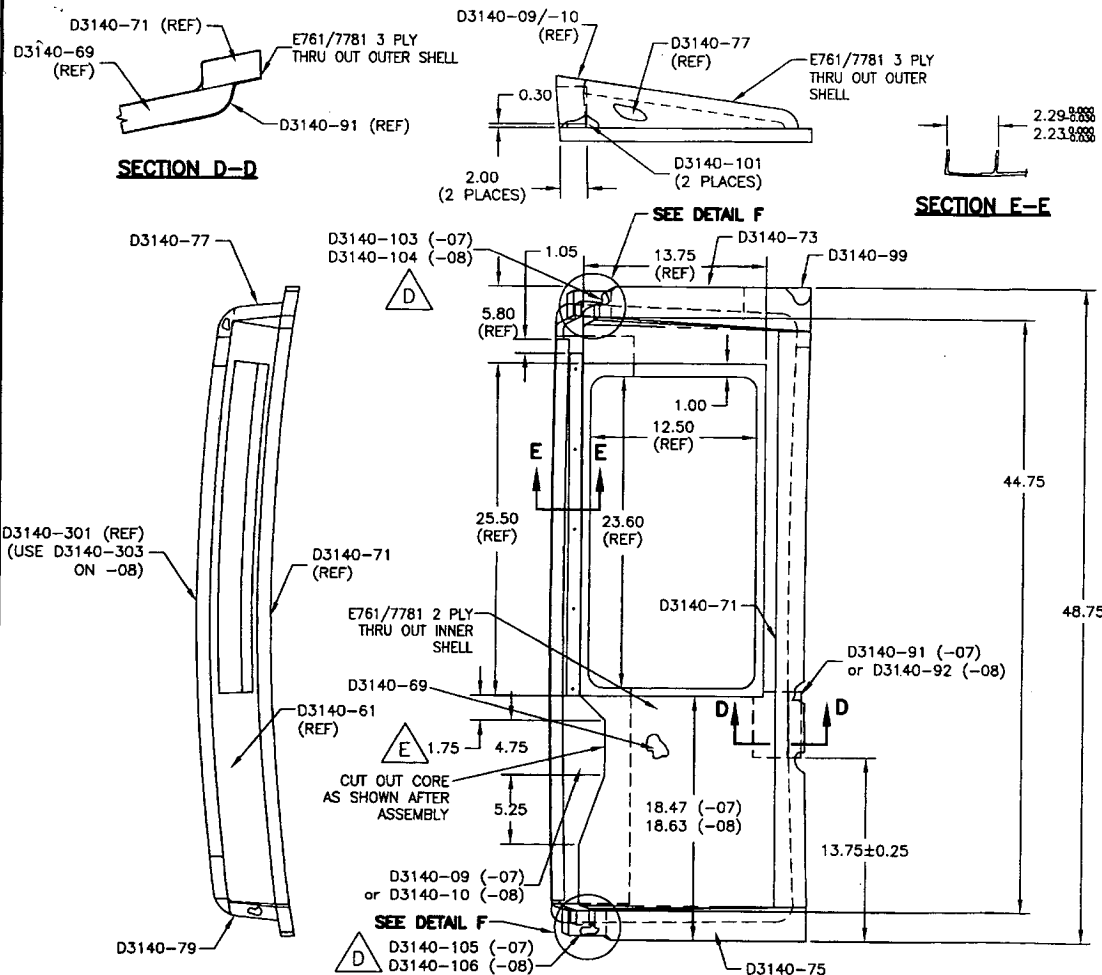
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**DART AEROSPACE LTD.**  
HAIRSEBURY, ONTARIO, CANADA

REV. F

SHEET 4 OF 7

SHEET 4 OF 7

DOOR

SCALE

NOTES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

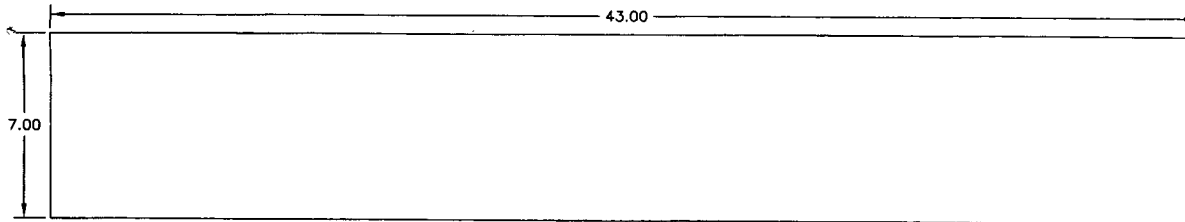
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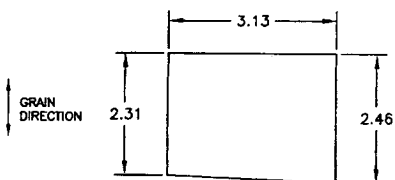
**NOTE:** Date & initial all entries



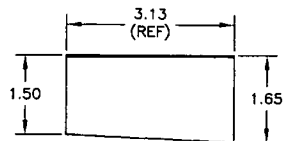


**D3140-87 DOUBLER**   
(REPLACES PREMIER P/N B30-23000-87)

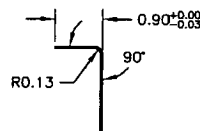
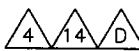
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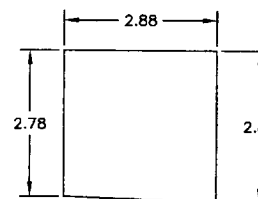
**D3140-105F FLAT PATTERN**  
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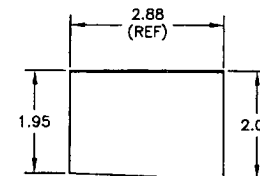
**D3140-105 DOUBLER**  
D3140-106 OPPOSITE



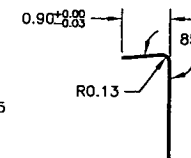
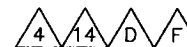
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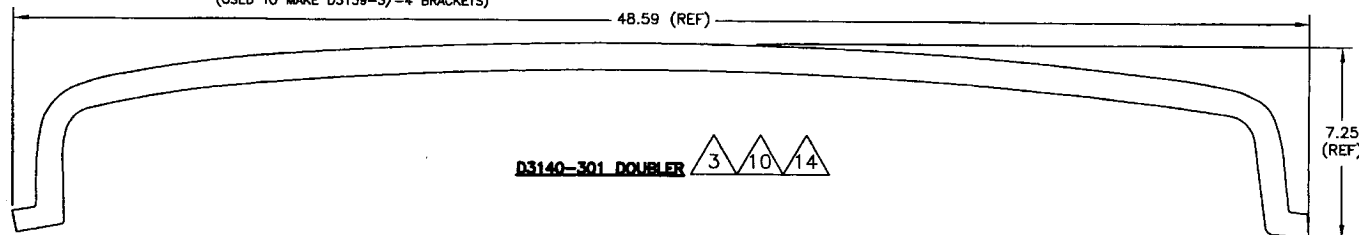
**D3140-103F FLAT PATTERN**  
(USED TO MAKE D3140-103/-104 BRACKETS)



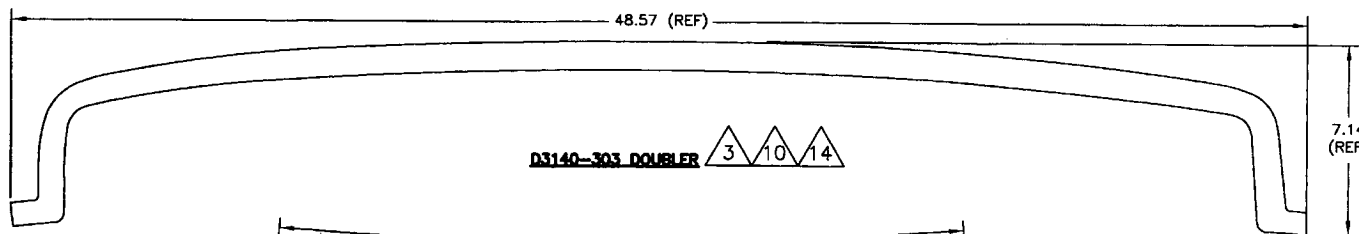
**D3140-104 DOUBLER**  
D3140-103 OPPOSITE



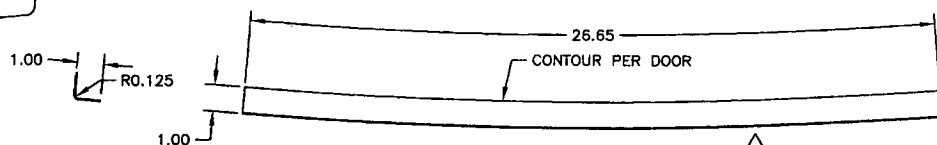
**D3159-3F FLAT PATTERN**  
(USED TO MAKE D3159-3/-4 BRACKETS)



**D3140-301 DOUBLER**



**D3140-303 DOUBLER**



**D3140-85 ANGLE**   
FLAT PATTERN: 26.65" x 1.90"  
(REPLACES PREMIER P/N B30-23000-85)

RELEASED  
06.11.13

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DESIGN		DRAWN BY	CB	<b>DART</b>	DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO.	D3140
DATE	06.10.06	TITLE	DOOR	REV. F	SHEET 6 OF 7
				SCALE	NTS

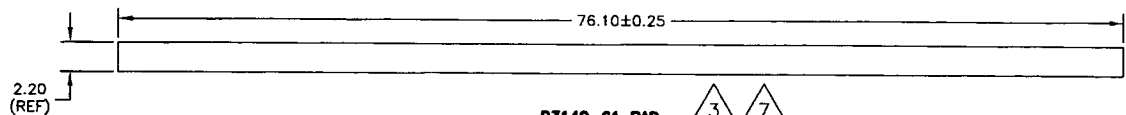
W/O:		WORK ORDER CHANGES					
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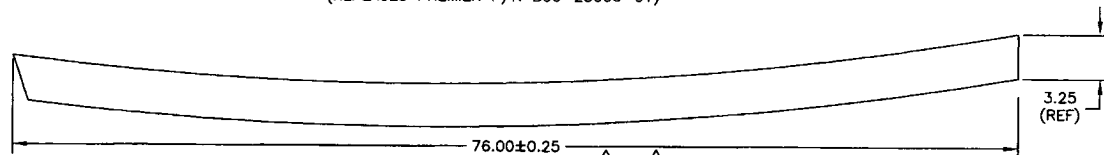
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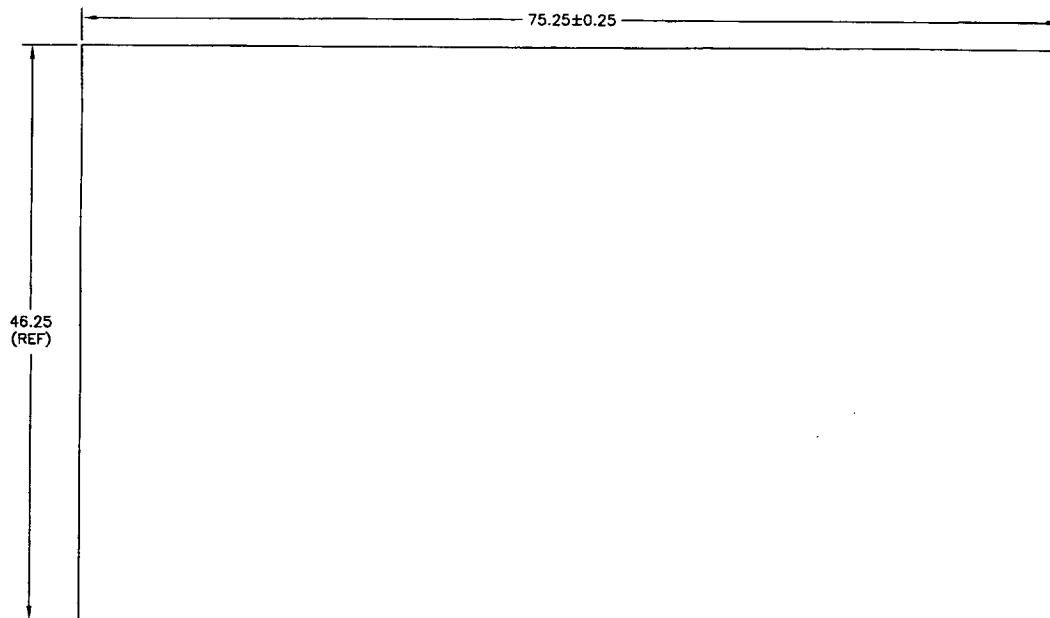
**NOTE:** Date & initial all entries



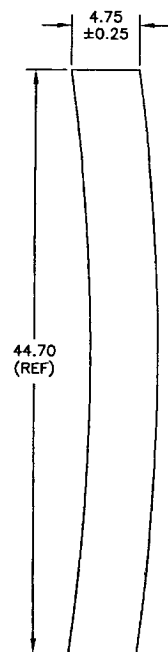
**D3140-61 PAD** 3 7  
(REPLACES PREMIER P/N B30-23000-61)



**D3140-63 PAD** 3 7  
(REPLACES PREMIER P/N B30-23000-63)

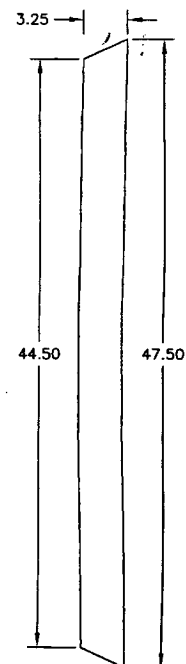


**D3140-59 PAD** 7  
(REPLACES PREMIER P/N B30-23000-59)



**D3140-57 PAD**  
(REPLACES PREMIER P/N B30-23000-57)  
3 7

84215



**D3140-241 DOUBLER** 5 14  
(REPLACES PREMIER P/N B30-23000-241)

RELEASED

06.11.13

R1.00  
(2 PLACES, REF)

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		DATE	TITLE	DRAWING NO.	REV. F
		06.10.06	DOOR	D3140	SHEET 7 OF 7
				SCALE	NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD	Work Order:	84215
Description: Double R	Part Number:	D3140-303
Inspection Dwg: D3140-303 Rev: F		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>B</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: <u>12-6-27</u>	Date: <u>12/6/27</u>	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	